

Work Order ID 137433

137433

Page 1

Wednesday, September 30, 2015 12:49:32 P

Item ID: D206-605-043 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Item Name: Rear Locker Extender Stop *NS2*
 Start Date: 9/30/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 10/09/15 Req'd Qty: 4.00 *4* Customer:
 Reference: REWORK (REPAINT)

Approvals: Process Plan: AS Date: 15-9-30 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4678	A								

105

0.00

105

QC

Quality Control

Memo

PULL FROM STOCK
 D206-605-043 X4
 BATCH:
 100228
 100229
 100230
 100231

TO BE REWORKED

0.00
SCRAP

4 AS-9-30

DAS		DATE RECEIVED	
PAYMENT	N/A	DATE RECEIVED	
P/N	D206-605-043	Q/C	CHG001
DESC	Rear Locker Extender	SC	SH01-61
LOT	B100231	SC	SR01420NY
MODEL	Bell 206A/B/L/L1/L3/L4	SC	
DATE APPROVAL 9-30-15		MADE IN CANADA	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Work Order ID 137433

137433

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Wednesday, September 30, 2015 12:49:32 P

Item ID: D206-605-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rear Locker Extender
 Start Date: 9/30/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/09/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference: REWORK (REPAINT)

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110	PURCHASING	0.00							
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110

Purchasing	Memo	0.00							
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Purchasing	Issue P/O: <u>29950</u>								
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Supplier:FDC.

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
 THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
 FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
 DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

115		0.00							
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115

Outsource7	Memo	0.00							
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Outsource rework	REWORK AS PER QUOTE 1278 REPAINT FINISH + TOOLING								
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ML5 OCT 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Wednesday, September 30, 2015 12:49:32 P

137433

Page 3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Rear Locker Extender

Stop *NS2*

Start Date: 9/30/15 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 10/09/15 **Req'd Qty:** 4.00

4

Customer:

Reference: REWORK (REPAINT)

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125 QC3- Inspect Part Finish

0.00

125

QC Memo

0.00

Quality Control

150		0.00
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150

Packaging	Memo	0.00
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Packaging	REPACKAGE USING NEW BATCH NUMBER
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160	QC21- Final Inspection - Work Order Release	0.00
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160

QC	Memo	0.00
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Quality Control

~~① 15-15-09~~ DAS
9
9-89
P.T.O.

DQA:

Date:

15/11/23



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/11/18

Work Order update only ☐

Work Order: <u>137433</u> Part No. <u>D206605-043</u> NCR No. <u>15-5442</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒																																																
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Large Fab ☐	Composite ☐	Supplier ☒																																																																		
Date: <u>15-10-14</u>	Step #: <u>115</u>	QTY Effective: <u>①</u>	MRB (29042) Approval <u>For WF</u> <u>15/11/18</u> <u>20/10/2015</u>																																																																	
Description Work Order Deviation found at receiving inspection a crack at the bottom of the rear locker R.C. Handling.		Disposition scrap → destroy		Completed By 9-89 OCT 16 2015 Lead hand / Supervisor Approval Verification DAS 9 9-89 15-10-14 QC / QA Coordinator Approval DAS 9 9-89 15-10-14																																																																
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Picklist Print

Page 1

Wednesday, September 30, 2015 12:49:38 PM

Work Order ID: 137433

137433

Parent Item: D206-605-043

D206-605-043

Parent Item Name: Rear Locker Extender

Start Date: 9/30/15

Required Date: 10/09/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.04.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-605-043

Manufactured

No

Each

0.0000

4

D206-605-043

**

Rear Locker Extender

15-9-30

B: 100228

229

230

231

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Design ☐	Operator ☐																																																																						
Doc/Data ☐	Offset/Setup ☐																																																																						
Equip/Tooling ☐	Supplier ☐																																																																						
Handling/Pre ☐	Training ☐																																																																						
Material ☐	Use for Testing ☐																																																																						
Internal Transport ☐	Poor Information ☐																																																																						
Tribal Knowledge ☐	Rushing ☐																																																																						
LOA ☐	Product Improvement ☐																																																																						
Substation ☐	Process Improvement ☐																																																																						
Past Expiry Date ☐	Manufacturing Process ☐																																																																						
Misidentified ☐	Past Due ☐																																																																						
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER :																																																																							



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29950**

Purchase Order Date 9/30/2015

PO Print Date 9/30/2015

Page Number 1 of 2

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer
Customer POID
Customer Tax #
Terms
Currency
FOB
Chantal Lavoie
10127-2607
Net 30
CAD
Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Ext
1	137432	D407-605-045 REAR LOCKER	10/16/2015 Yes 10/16/2015		7.00	\$195.00	\$1,370.00

REWORK D407-605-045 REARLOCKER, RE-PAINTING
B100218
B100220
B100221
B100222
B100223
B100224
B100225

2 137433

D206-605-043 REAR
LOCKER

10/16/2015
Yes
10/16/2015

4.00

\$195.00

\$1,580.00

RE-WORK D206-605-043 REAR LOCKER, RE-PAINTING
B100228
B100229
B100230
B100231
DAS
9
9-89

PO Instructions: QUOTATION NO. 1278

Note:

9/30/2015

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél. : 450 357-1344

Bon de livraison

05/10/2015

Commande : 2250
Référence : PO #029950/2

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél.: 1 613 632-9577

No item	Description/	Qté	Qté livrée	Qté B/O
D206-605-043	REAR LOCKER EXTENDER PO item: 29950/2 Lot: B100231 15/11/12 SV	1	_____	_____

Transport : _____

Nb colis : _____

Marchandise reçue : _____

Réf. : _____



ANALYSIS REPORT

SCC Accreditation No.: 40‡

Mr Sylvain Santerre
FDC Composites Inc.

Date: October 2, 2015
Report: S1233-013-84264A

IDENTIFICATION: Composite: DAE001-38, 2015-05-22
Received: September 30, 2015; PO#: 2951

STANDARD:

TEST: Paragraph 4: Vertical test - 60 seconds FAR 25.853 Appendix F Part I
(b)-Par.4*1

TEST CONDITIONS: *1Incorporates Amendment 25-111, Eff. 09/02/2003.
Sample conditioned ($70 \pm 5^\circ\text{F}$ ($21 \pm 3^\circ\text{C}$), $50 \pm 5\%$ R.H.);
Gas used: Methane; Ignition time: 60 seconds.
Direction of weave corresponding to the most critical flammability: N/A
Date tested: October 02, 2015

RESULTS:	Individual Data					Avg.	S.D.	% CV
Burn length (in):	3.6	4.4	3.8	3.9	4.1	4.0	0.3	7.7
Flame time (s):	0.0	0.0	0.0	1.2	4.0	1.0	1.7	166.8
Dripping ?	no	no	no	no	no			

REQUIREMENTS: For materials covered by par. (a)(1)(i):

- The average burn length may not exceed 6 inches;
- The average flame time after removal of the flame source may not exceed 15 seconds;
- Drippings from the test specimen may not continue to flame for more than an average of 3 seconds after falling.

Prepared by:

Julien Gagné
Julien Gagné, Tech.
Technician

Approved by:

Edith D. Mail
For: Eric Blond, Eng., M.Sc.A. Date: October 2, 2015
Vice-President

****For any information concerning this report, please contact Eric Blond****

The reports are identified by an alphanumeric code, the last character refers to the number of revision(s), this is emitted in ascending order. The samples in relation to this test are retained for a period of 30 days following the expedition day of the written report, unless other instructions are received. The fees for all services after the tests are 125.00 \$ per hour and for appraisal in Court, 195.00\$ per hour. The above reported results refer exclusively to the samples submitted for evaluation. This analysis report cannot be partly used or reproduced, unless in whole, without CTT Group prior written consent. ‡ CTT Group is accredited by the SCC for specific tests as listed on www.scc.ca. For customer's complete address, please refer to the front page.



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 29950

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Vendor Part Number</u>	<u>Description</u>	<u>Lot</u>
2	1	D206-605-043	137433	Rear Locker Extender	B100231

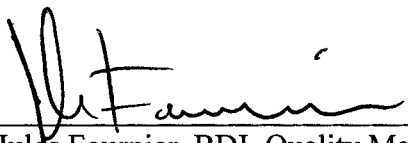
NOTE :

Operation performed : interior surface re-painting as specified on Darts's PO by sanding gelcoat to remove cracks and application of PPG 6941241A 2C Acrycote White paint Lot 00022.
Catalyst was PPG 794002 2C Acrycote Lot 98841.

Catalysed PPG acrycote paint complies with FAR 25.853 Appendix F Part I (b)-Par.4 (Vertical Test 60 seconds). See attached Analysis Report from CTT Group.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: _____


Jules Fournier, BDI, Quality Manager

Date: 2015-10-05